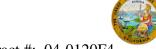
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Spherical Bushing Ring Bearing (Hinge K)

Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 72.28

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-016123 Address: 333 Burma Road **Date Inspected:** 27-Jul-2010

City: Oakland, CA 94607

34-0006

**Project Name:** SAS Superstructure **OSM Arrival Time:** 830 **OSM Departure Time:** 1230 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Lubrite **Location:** Meadville, PA

**CWI Name:** Dean Gamble **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No

Yes No N/A **Delayed / Cancelled:** 

**Component:** 

### **Summary of Items Observed:**

**Bridge No:** 

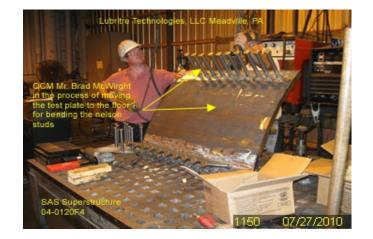
Caltrans Quality Assurance (QA) Inspector Sherri Brannon was present at Lubrite Technologies in Meadville, PA as requested to witness stud welding the Procedure Qualification Record (PQR) for the Spherical Bushing Ring Bearing (Hinge K) Bid item #46(S) to be used on the San Francisco / Oakland / Bay Bridge (SFOBB), Self Anchored Suspension (SAS).

QA Inspector Brannon met with QCM Mr. Brad McWright and was provided Material Test Reports (MTR) for the following materials: Base Material - ASTM A709, Grade 50, heat number 0502434 and Stud Material - Nelson Stud, ASTM A108/A29 Grade 1015, 1" x 8-1/4" (size), heat number 5093721 and with mechanical properties to AWS D1.5:2002 Table 7.1 Type B and Ferrule Material -Full base ceramic ferrule number 100101045. QA Inspector Brannon reviewed the MTR and verified the materials as they were presented, which appeared to comply with contract documents.

QA Inspector Brannon witnessed Lubrite welder Mr. Gregg Zimmerman perform the stud welding for Stud Welding Procedure Qualification Record (PQR) number 9103823. QA Inspector Brannon observed CWI Mr. Dean Gamble monitor the PQR test and perform the applicable inspections. See Caltrans Welding Witness Report, TL-6032 dated July 27, 2010 for additional information.

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)









## **Summary of Conversations:**

As stated within this report.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon,Sherri	Quality Assurance Inspector
Reviewed By:	Hager,Craig	QA Reviewer